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ASAP - ASAP - ASAP

D4151-1
Job Sheet 175315



Part No: D4151-1

Job Qty: 20 ea

Part Name: Lower Hardpoint Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/3/18

Job Tracking No:

Due Date: 4/5/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEET 2 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	4/4/18	4/4/18	0.00	0.00	Start Up Waterjet		<i>ac 18/04/03</i>
100	Waterjet	20 pcs	4/5/18	4/5/18	0.00	0.77	Waterjet1		<i>ac 18/04/03</i>
120	QC	20 pcs	4/5/18	4/5/18	0.00	0.00	QC8		<i>38</i>
150	Packaging	20 pcs	4/5/18	4/5/18	0.00	0.00	Packaging3	<i>Start up</i>	<i>APR 04 2018</i>
160	QC21-SA	20 Ea	4/5/18	4/5/18	0.00	0.00	QC21	<i>21</i>	<i>APR 06 2018</i>

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.0160 sf (.0508 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	1	119	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Hardpoint Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Lower Hardpoint Plate	0.252Inches + 0.003 - 0.000	0.255 0.252	Diameter	
3	Lower Hardpoint Plate	0.375Inches ± 0.010	0.385 0.365		
4	Lower Hardpoint Plate	3.128Inches ± 0.010	3.138 3.118		
5	Lower Hardpoint Plate	1.000Inches ± 0.010	1.010 0.990		
6	Lower Hardpoint Plate	0.500Inches ± 0.030	0.530 0.470		
7	Lower Hardpoint Plate	3.660Inches ± 0.030	3.690 3.630		
8	Lower Hardpoint Plate	2.000Inches ± 0.030	2.030 1.970		
9	Lower Hardpoint Plate	1.000Inches ± 0.003	1.003 0.997		
10	Lower Hardpoint Plate	0.125Inches ± 0.010	0.135 0.115		

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								